

Date: Monday, 3/27/2006 7:37:44 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 26381
 Estimate Number : 12352
 P.O. Number : N/A
 This Issue : 3/27/2006 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : 3/24/2006 Type : PURCHASED PARTS
 Previous Run : N/A
 Drawing Name : SCREEN
 Part Number : D34755
 Drawing Number : D3475 REV A
 Project Number : N/A
 Drawing Revision : A
 Material : N/A
 Due Date : 3/31/2006 Qty: 80 Um: Each
 Written By : SEE COMMENT BELOW
 Checked & Approved By : 06.03.27
 Comment : Est Rev:A New Issue 06-03-24 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D34755P Screen



Comment: Qty.: 6.6662 sf(s)/Unit Total: 533.2960 sf(s)
 Screen

2.0 PG PURCHASING



Comment: Issue P/O: 00000829
 304 4MESH SCREEN, .047" WIRE DIA,
 OPENING .203", 65% OPEN AREA
 Supplier: Accurate Screen
 Material Certification Required
 Note: Check Stock Before Ordering

AP
06/03/20

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 Receive & Inspect For Transit Damage
 Ensure material certification is attached

06/4/3

(96)

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

060406

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1

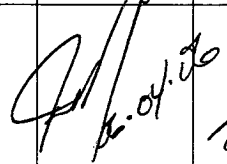
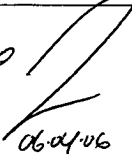



Comment: SMALL & MEDIUM FAB RESOURCE 1
 Fabricate as per Dwg D3475

N/A
F

96
P10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-04-06	5.0	Not to fabricate Mat'l yet. Stock Roll until parts are needed.				 06-04-06	 06-04-06

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA:  Date: 06/04/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 3/27/2006 7:37:45 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SCREEN

Job Number: 26381

Part Number: D34755

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



N/A
2

Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



06.04.06

56PF²

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST

8.0

DC

DOCUMENT CONTROL



96PF

Comment: DOCUMENT CONTROL

Inspection Level 21

06/04/10

Job Completion



u 06.04.07

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector



Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

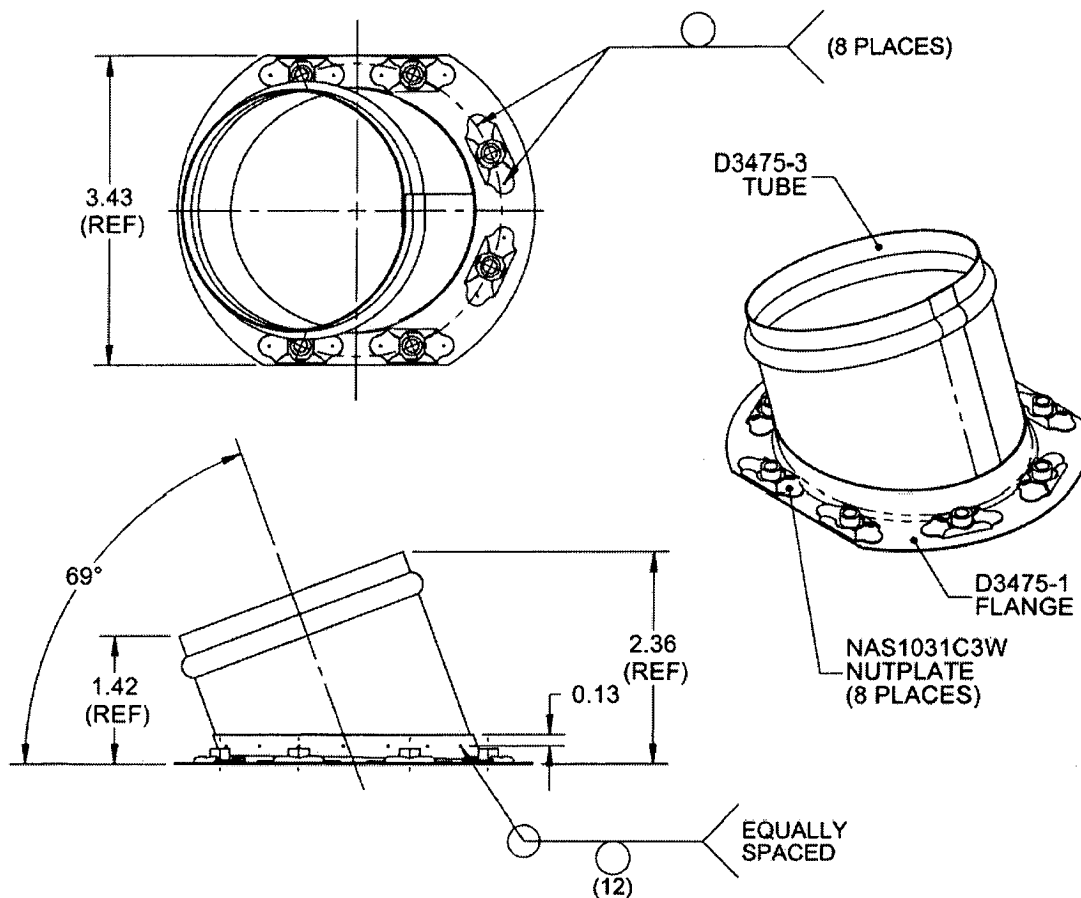
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PRELIMINARY ISSUE

DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3475	REV. A SHEET 1 OF 6
DATE 06.01.24		TITLE DUMP OUTLET	SCALE 1:2
A	06.01.24	NEW ISSUE	



D3475-041 DUMP OUTLET

NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: ELECTRO CHEMICALLY POLISH
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

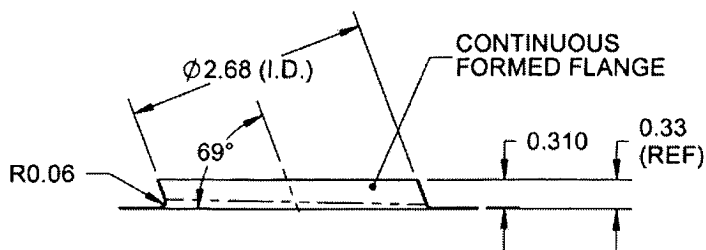
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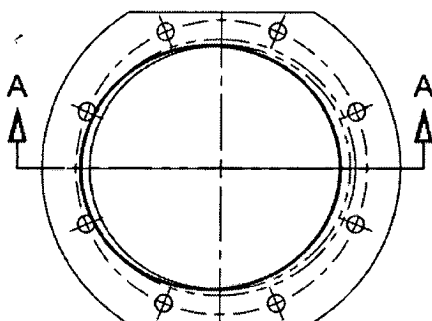
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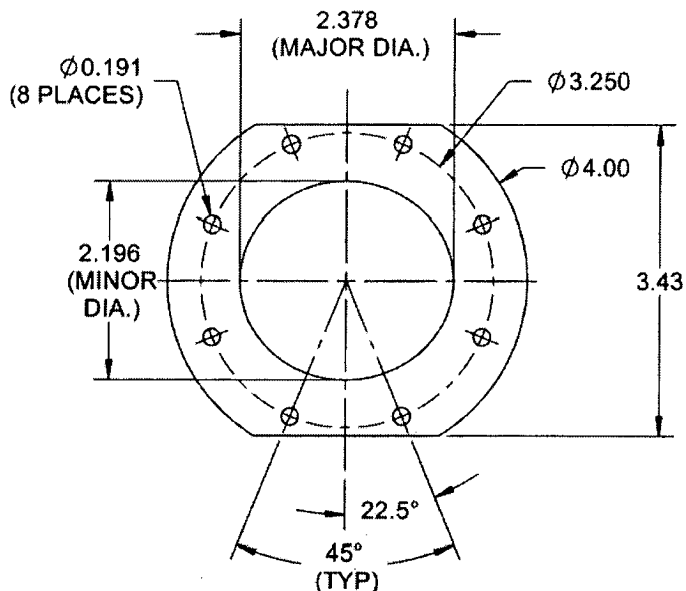
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DATE 06.01.23		TITLE DUMP OUTLET	SCALE 1:2



SECTION A-A



**D3475-1 OUTLET
ADAPTER PLATE**



D3475-1F FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

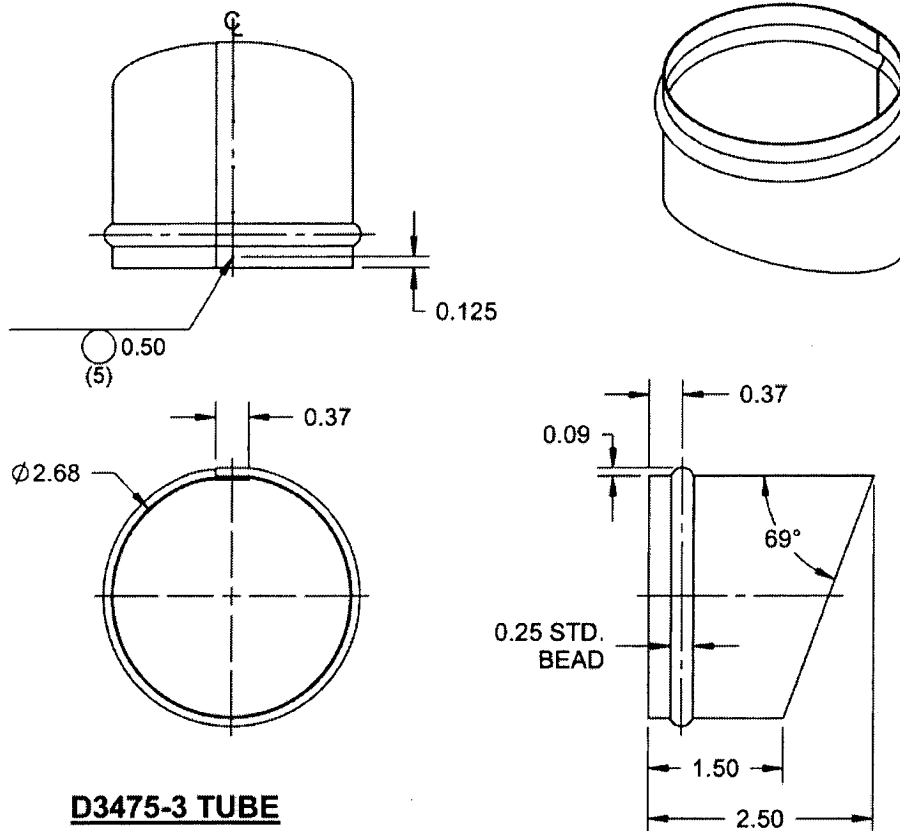
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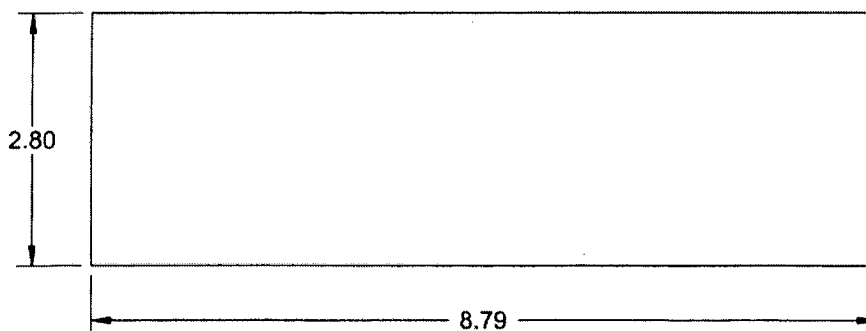
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DATE 06.01.24		TITLE DUMP INLET	SCALE 1:2



D3475-3 TUBE



D3475-3F TUBE FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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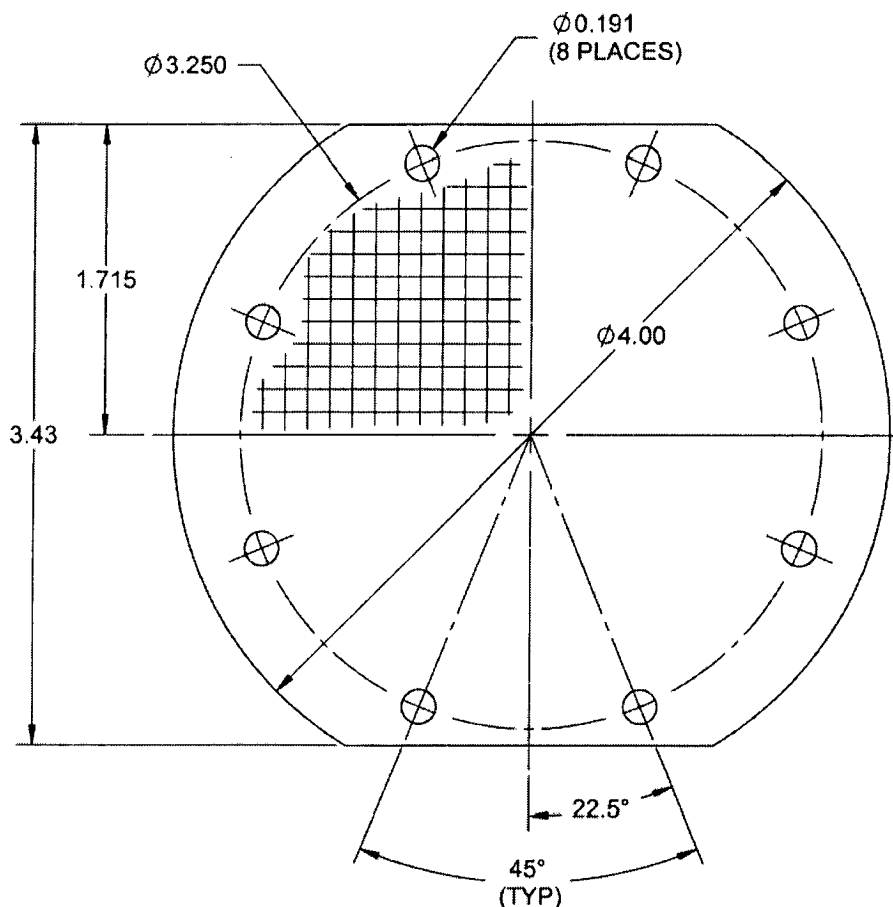
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DATE 06.01.24		TITLE DUMP OUTLET	SCALE 1:1



D3475-5 SCREEN

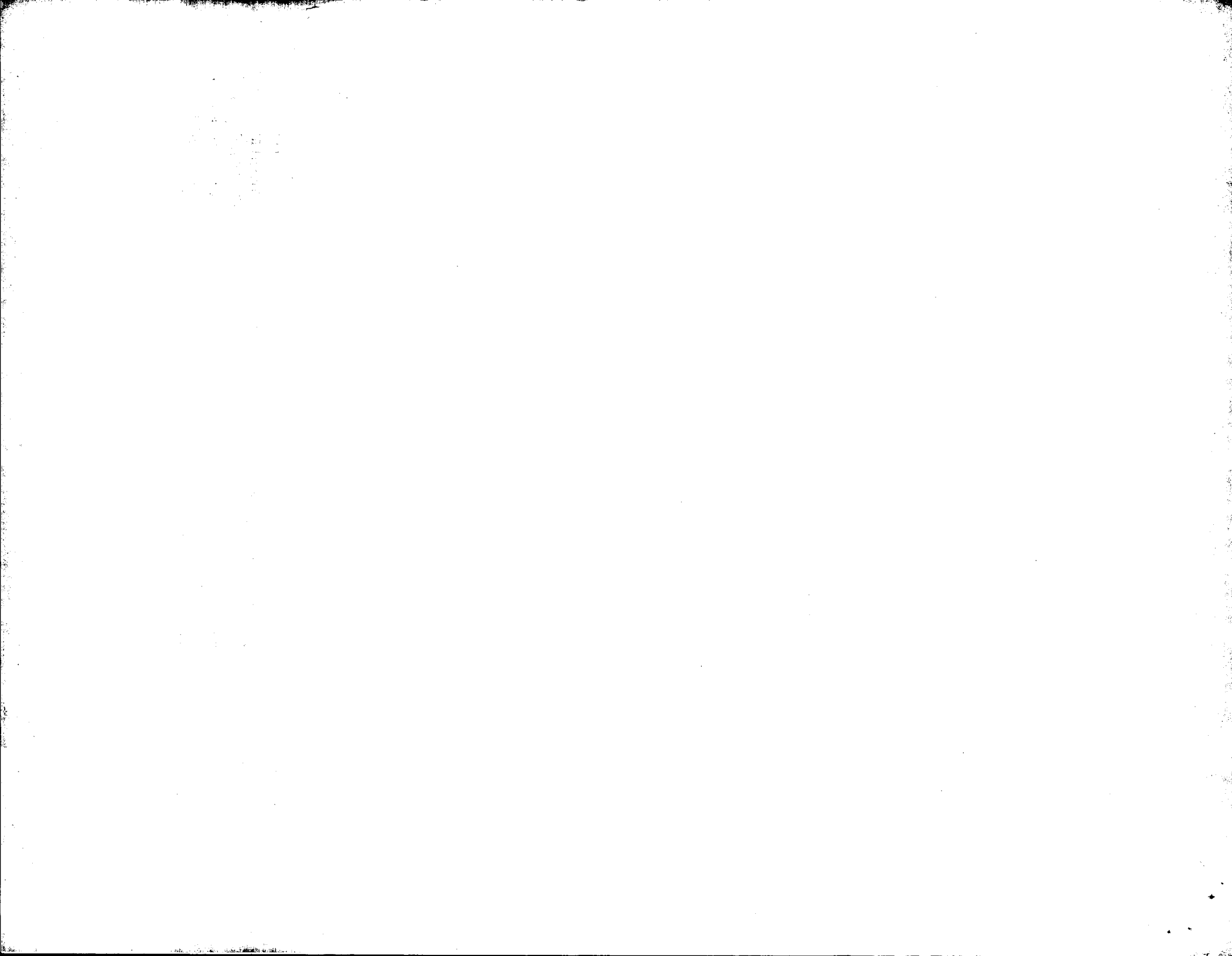
NOTES:

- 1) MATERIAL: 4 MESH SCREEN, $\phi 4.00$ " X 0.025" THICK
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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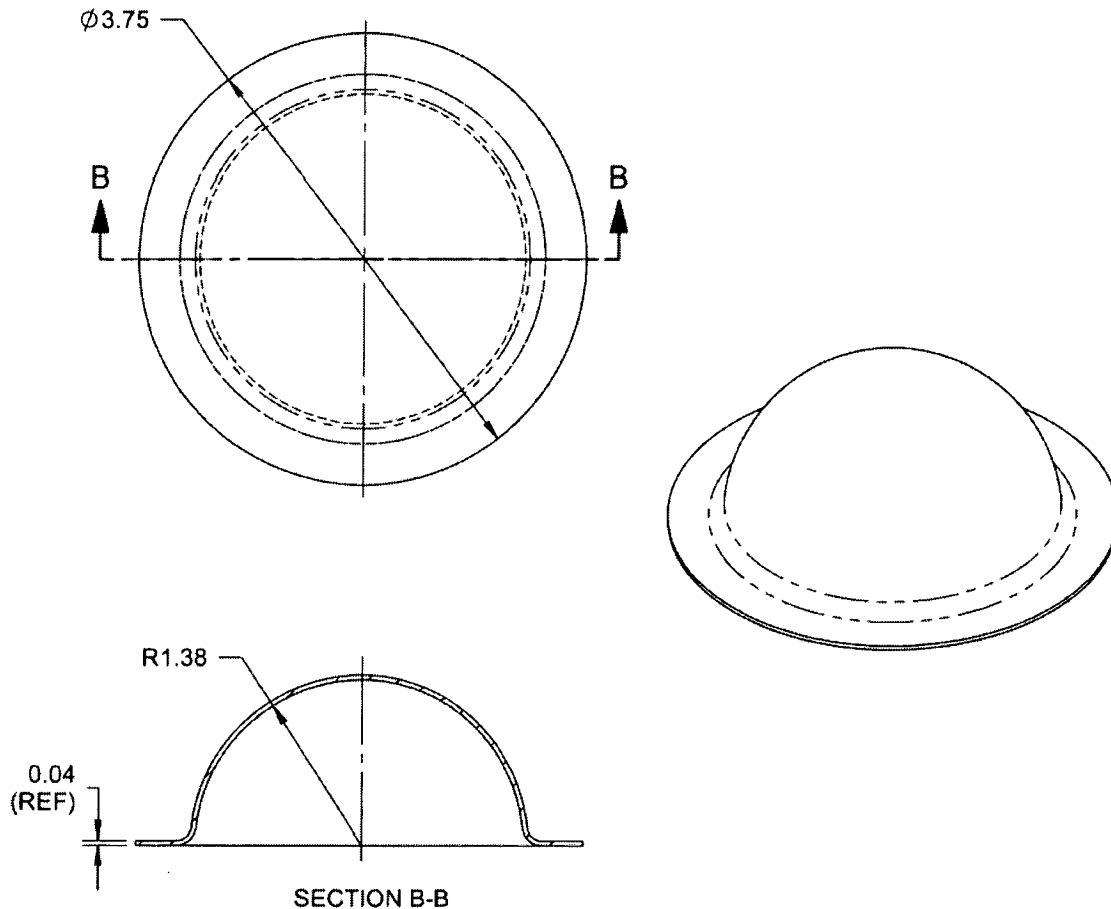
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DATE 06.01.24		TITLE DUMP OUTLET	SCALE 1:1.5



D3475-7S SCOOP OUTLET

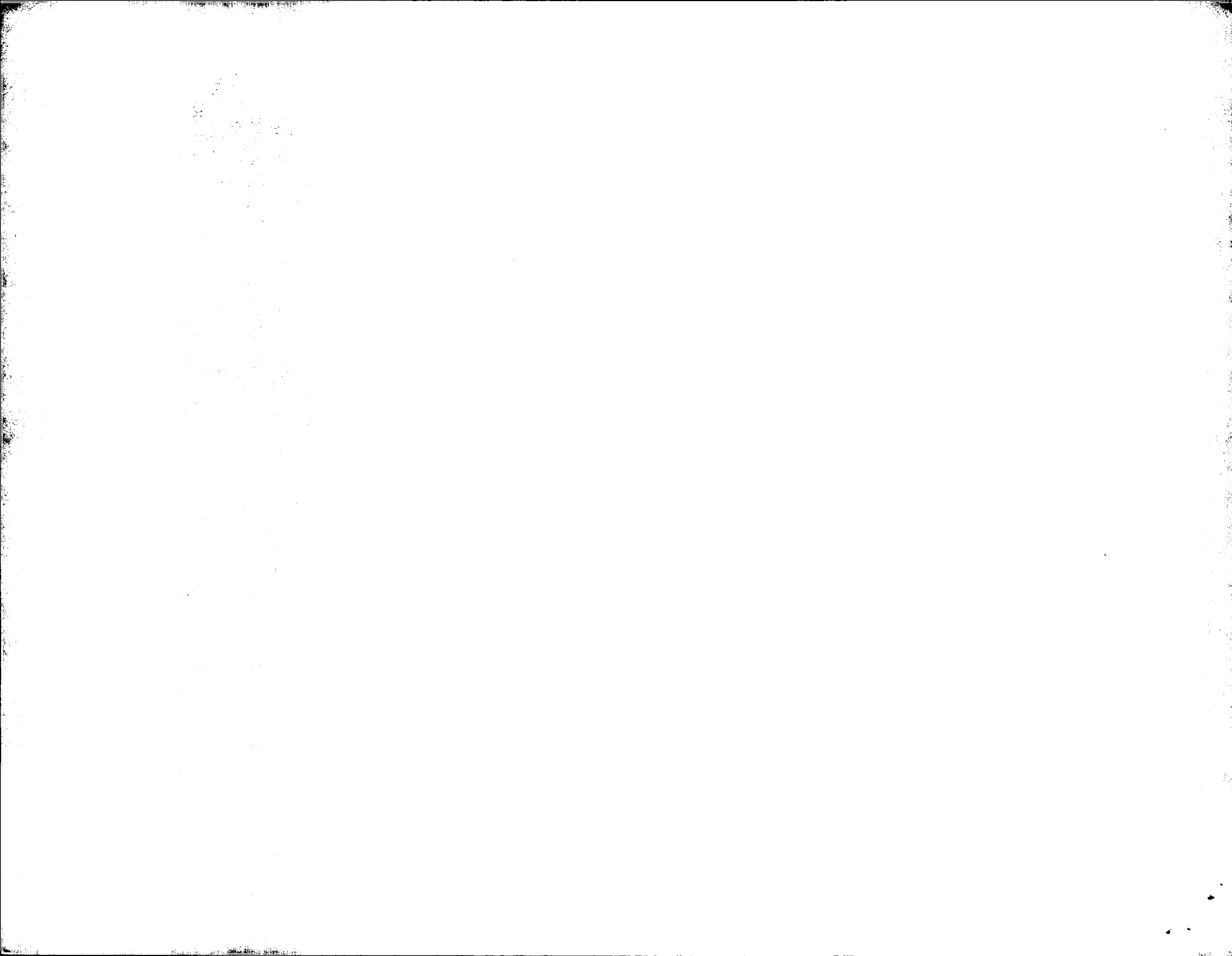
NOTES:

- 1) MATERIAL: 2024-0 ALUMINUM SHEET, 0.040" THICK PER AMS-QQ-A-2505/4 OR AMS 4037 (REF. DART SPEC. M2024T3S.040)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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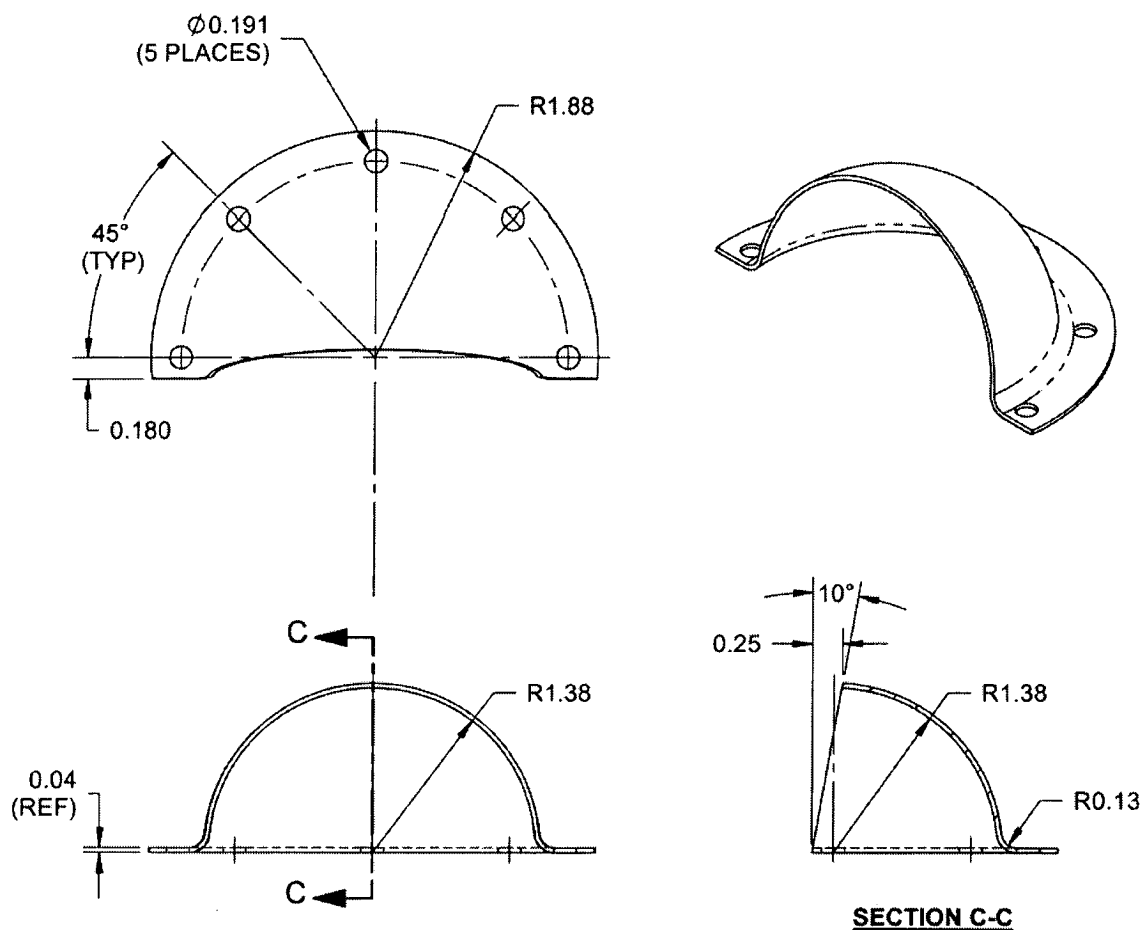
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DATE 06.01.24		TITLE DUMP OUTLET	SCALE 1:1.5



D3475-7 SCOOP OUTLET

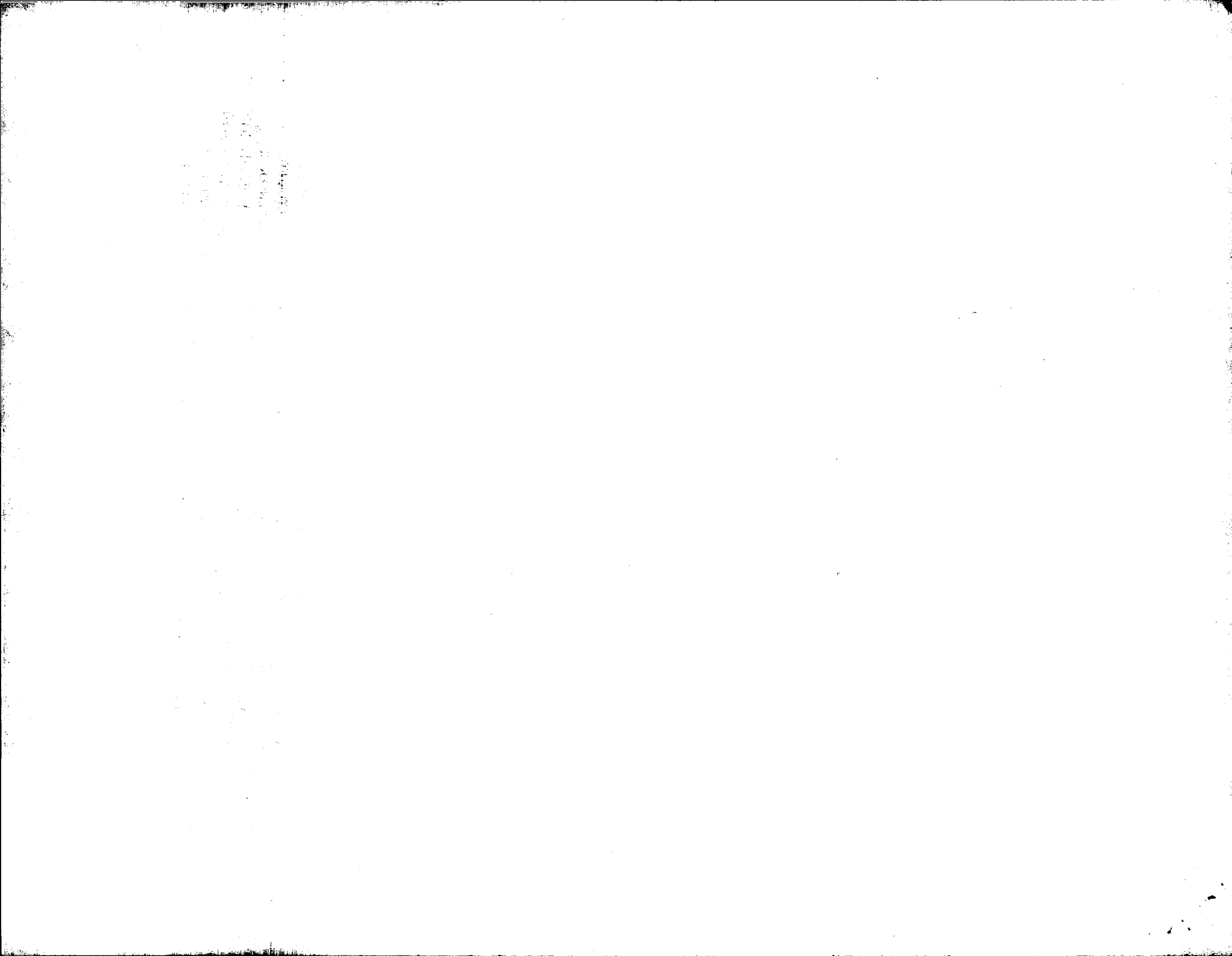
NOTES:

- 1) MATERIAL: MAKE FROM D3475-7S
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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ACCURATE SCREEN LTD

Bay E 8080 - 36 St SE
Calgary, Alberta T2C 2J4
Canada

Ph: 403-723-0323 Toll Free: 877-857-0323 Fx: 403-236-0703

EMAIL: sales@accuratescreen.ca

PACKING SLIP

Order No.: 829
Date: 22-Mar-2006
Page: 1

Sold To:

Dart Aerospace Ltd
613-632-4443
1270 Aberdeen St
Hawkesbury, Ontario
Canada K6A 1K7

Ship To:

Dart Aerospace Ltd
613-632-4443
1270 Aberdeen St
Hawkesbury, Ontario
Canada K6A 1K7

Business No.: 86618-5080-RT001

Shipped By FEDEX COLLECT

Item No.	Ordered	Unit	Description
MTAcustom	80	SF	Woven Custom SF T 304 ST ST WOVEN 4 MESH X .047 X 4' X 20' MILL CERTIFICATES REQUIRED THX BOB 52 LBS Terms: Net 30

* CHECK US OUT AT WWW.ACCURATESCREEN.CA *

CHECKOFF : MATERIAL: _____ WT: _____ DIMENSION: _____

Material STAINLESS STEEL Type 304			
Number per	1.0	Inch	4
Aperture		Inch	.0000

Batch-No.	56-327	WARP
-----------	--------	------

JIS G4309-99 - 304 Specifications		
Elements	Actual Value	Min / Max
C - Carbon	0.060	Max. 0.080
Si - Silicon	0.740	Max. 1.000
Mn - Manganese	1.330	Max. 2.000
P - Phosphorus	0.029	Max. 0.045
S - Sulfur	0.003	Max. 0.030
Cr - Chromium	18.790	18.000 - 20.000
Ni - Nickel	8.020	8.000 - 10.500
Mo - Molybdenum		-
Cu - Copper		-
N - Nitrogen		-

Elongation %	40.00
Yield Strength N/mm2	666.00
Tensile Strength Kg/mm2	68.00

Material STAINLESS STEEL Type 304			
Number per	1.0	Inch	4
Aperture		Inch	.0000

Batch-No.	56-327	SHUTE
-----------	--------	-------

JIS G4309-99 - 304 Specifications		
Elements	Actual Value	Min / Max
C - Carbon	0.060	Max. 0.080
Si - Silicon	0.740	Max. 1.000
Mn - Manganese	1.330	Max. 2.000
P - Phosphorus	0.029	Max. 0.045
S - Sulfur	0.003	Max. 0.030
Cr - Chromium	18.790	18.000 - 20.000
Ni - Nickel	8.020	8.000 - 10.500
Mo - Molybdenum		-
Cu - Copper		-
N - Nitrogen		-

Elongation %	40.00
Yield Strength N/mm2	666.00
Tensile Strength Kg/mm2	68.00

We certify that the above wire cloth was manufactured in accordance with standard mill practices.

06-01-06